

Date: Tuesday, 12/6/2005 9:24:51 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR PROTECTOR AFT RH
<b>Job Number</b> : 25123	
<b>Estimate Number</b> : 11235	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D32814
<b>This Issue</b> : 12/6/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3281 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT Below	<b>Due Date</b> : 12/30/2005 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : SEE COMMENT Below	
<b>Comment</b> : Est Rev:A 04.07.01 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING  
 Issue P/O: 192  
 Description: Floor Protector Aft RH  
 Possible Supplier: Delastek  
 Certificate of Conformity is required

W JS-1206  
 12/31/30

2.0	D32814	Floor Protector, Aft RH
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
 Floor Protector, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure certificate of conformity is attached

12/31/30

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK  
 Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

12/31/31 20 P10

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

12/31/31 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/6/2005 9:24:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 25123

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

54C 06/02/01

20

20 06/02/01

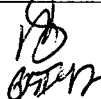
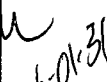
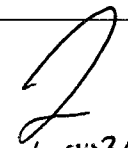


Job Completion



PIO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

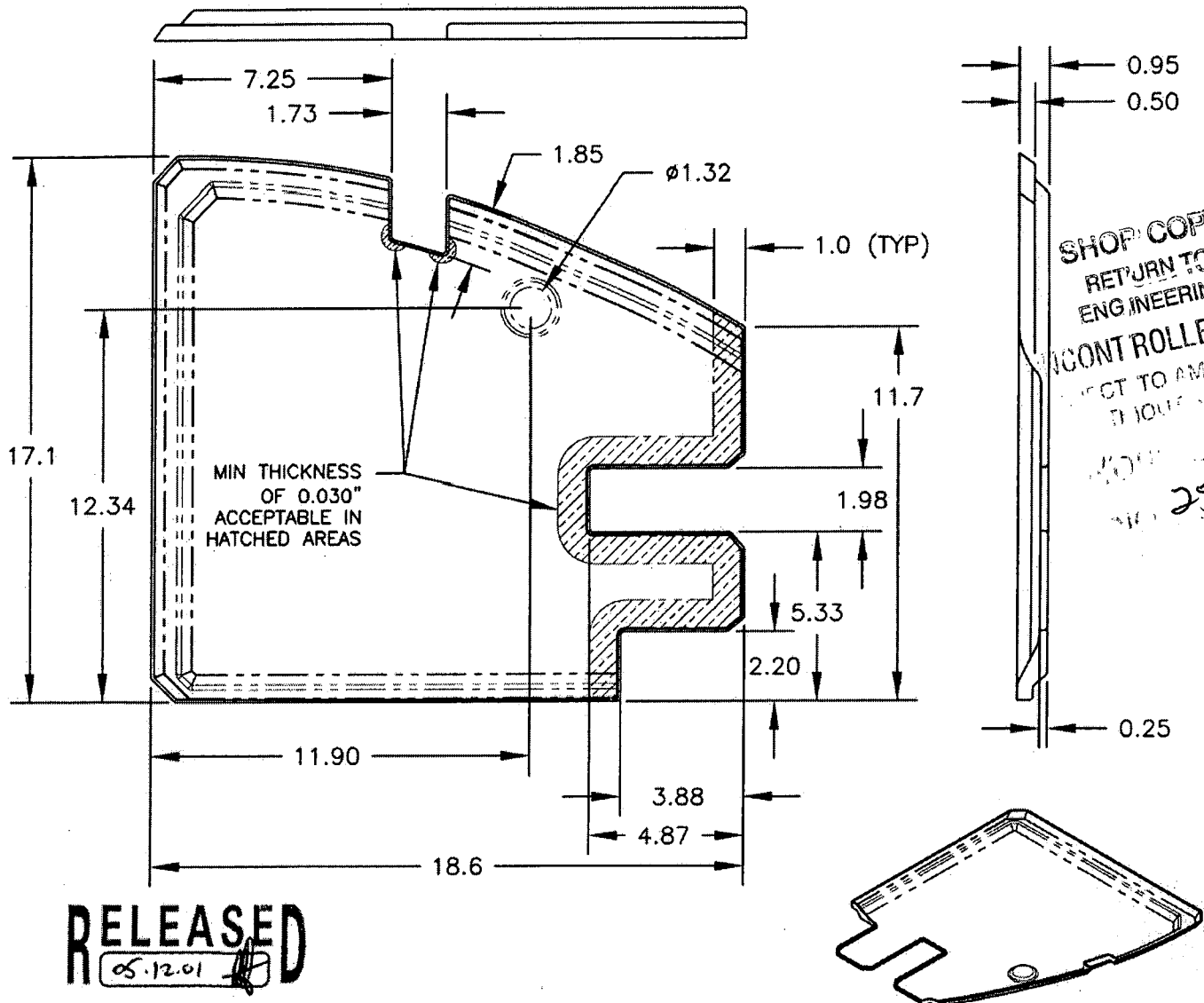
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 1 Date: 26/02/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-31	4	Delastek W/O reads A LH floor, but the part # is A RH.		Parts are good and are RH. (-4) Notify Delastek and have them change the W/O to RH, so there is no confusion on ordered parts.	 06-01-31	 06-01-31		 06-01-31

NOTE: Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**D3281-1 FLOOR PROTECTOR, FWD LH**

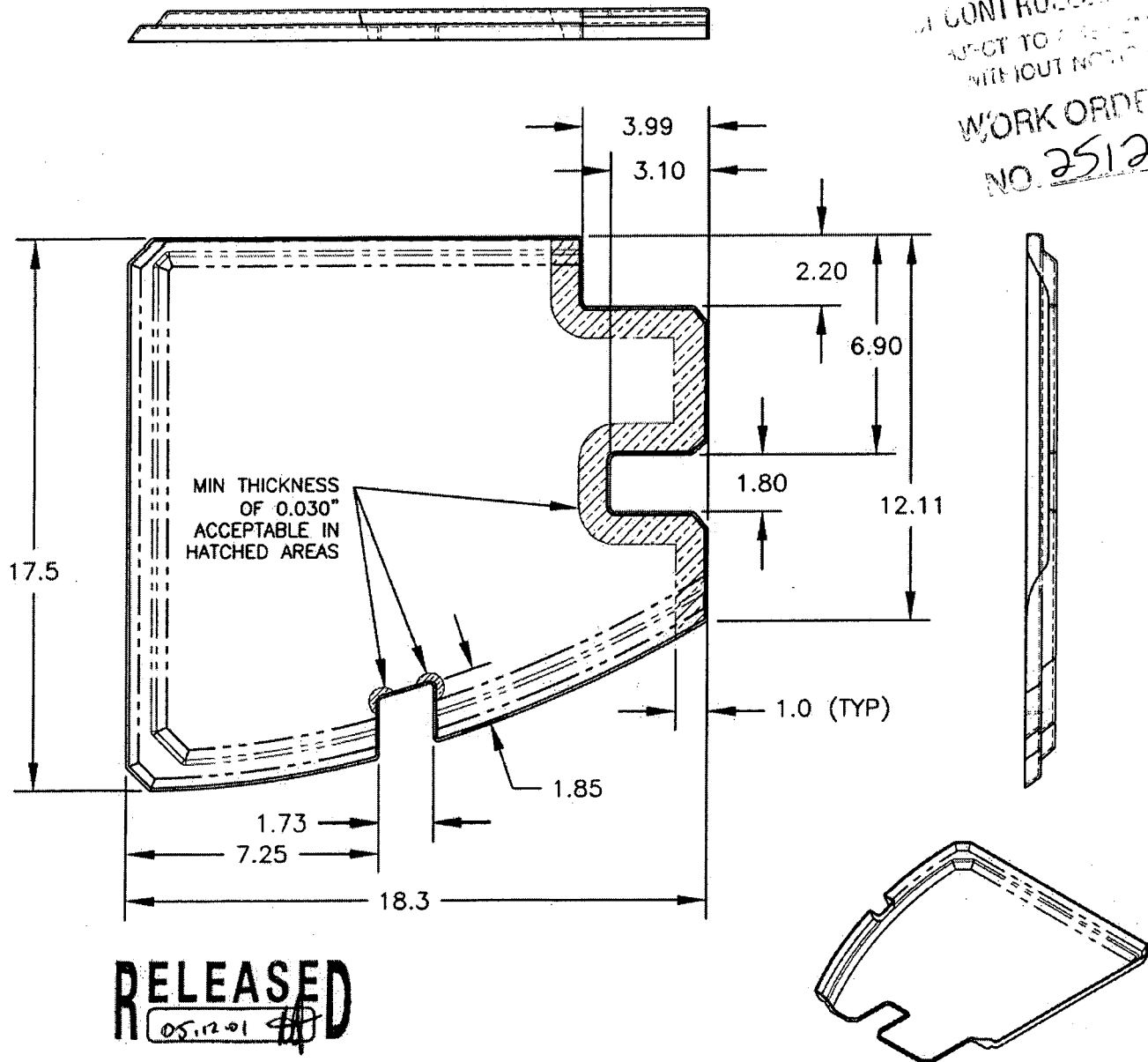
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**D3281-2 FLOOR PROTECTOR, FWD RH**

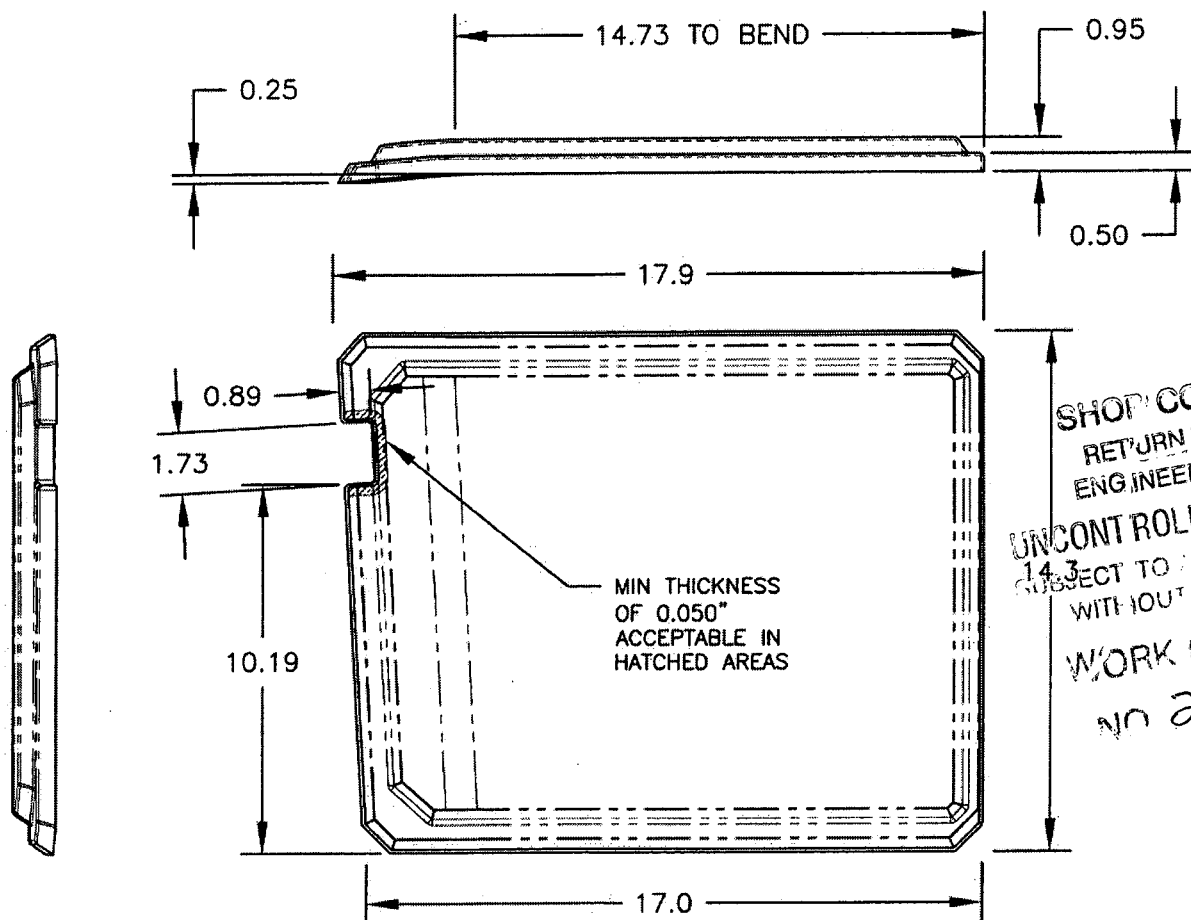
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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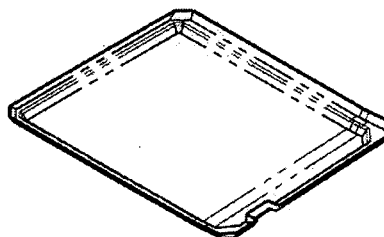
**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
14.3  
SUBJECT TO  
WITHOUT  
WORK OFF  
NO 25123

RELEASED  
05.12.01. *[Signature]*



**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**  
**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2  
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	9876
Customer #	DART

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:  
Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:  
Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/01/06	05/12/05	4333	Linda Lacelle		PO00000192		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	20	DKC134-0044	Floor Protect Part 1 N° D3281-1 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32263			
20	0	20	DKC134-0045	Floor Protect Part 2 N° D3281-2 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32264			
20	0	20	DKC134-0046	Floor Protect Part 3 N° D3281-3 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32265			
20	0	20	DKC134-0047	Floor Protect Part 4 N° D3281-4 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32266			
				J 06.01.31			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



## Feuille de Procédé

Client : DART Dart Aerospace Ltd.  
Numéro Job : 32266  
Numéro Soumission : 2386  
Numéro B.A. :  
Cette fois : 2005-12-21 No. B.V. :  
Prsht Rev. : NC  
Prem. fois : - - Type :  
Job précédente : 32058

Nom Dessin : FLOOR PROTECTOR AFT, LH  
Numéro Article : DKC134-0047  
Numéro Dessin : D3281  
Projet Numéro : DKC134  
Révision dessin : B  
Matériel : F6006  
Date Dûe : 2005-12-28 Qté: 20 UdM: UNITE

Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce: D3281-4  
Process Sheet Rév.: 00

Produit additionnel

Numéro Job: 

# Séq.: Machine ou Opération: Description :

1.0 APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Total : 3.340 UNITE(s)  
Lexan F6006 Noir N° 700 48" x 96" x

N° de Lot:

APL0016



1-5327-1

2.0 SÉCHAGE/ANEAL

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.  
# Bon achat: 5327



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs  
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.  
Inscrire sur la charte de température le numéro de Job du matériel au séchage.  
# de cuisson: 4714

3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs  
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.



Quantité: 20 Date: 12-1-06 Sceau:

Quantité: Date: Sceau:

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 32266

Numéro Article: DKC134-0047

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
THERMOFORMAGE DES PIECES

F.O: 16jan06



Faire le thermoformage du " Floor Protector " N° D3281-4 à l'aide du moule N° D3281-4T1 sur le  
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.



Quantité: 20 Date: 16-1-06 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
TRIMAGE PLASTIQUE DART

F.O: 17jan06



① Faire le trimage du " Floor Protector " N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

② Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

① Quantité: 20 Date: 17/01/06 Sceau: \_\_\_\_\_



② Quantité: 20 Date: 23/01/06 Sceau: \_\_\_\_\_



6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 26jan06 Sceau: \_\_\_\_\_



7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 32266

Numéro Article: DKC134-0047

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

N° de pièce: D3281-4

N° de Job: \_\_\_\_\_

Date de fabrication: \_\_\_\_\_

Sceau d'inspection.

Quantité: 20 Date: 24-01-06 Sceau:  40

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs


EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-4

Date de fabrication: \_\_\_\_\_

N° de job: \_\_\_\_\_

Quantité: 20 Date: 24/1/06 Sceau:  23

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_